

Work Order ID 83680 -1

Wednesday, May 16, 2012 1:02:41 PM

*split * Duplicate **
83680

Page 1

Item ID: D4016-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Lid

Start Date: 4/23/2012 Start Qty: 18.00

18

Cust Item ID:

Required Date: 4/30/2012 Req'd Qty: 18.00

18

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK as per folio

mk 12/05/22

4 0

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

mk 12/05/22

4 0

2. 14. 1934

1934-1935

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8.3680

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/23/2012 **Start Qty:** 18.00

18

Cust Item ID:

Required Date: 4/30/2012 **Req'd Qty:** 18.00

18

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

QC2- Inspect parts off machine FAI/FAIB

0.00

on 12/05/22

4

120

QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

0.00

SL 12-05-20

4

130

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: MB

9.00

160

Packaging

Memo

0.00

Packaging

4 ll
12.05.22

12/1/20
- 10/1/20 -

12/1/20
- 10/1/20 -

12/1/20 (10/1/20)

12/1/20
- 10/1/20 -

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- 10/1/20 -

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12/1/20

Work Order ID 83680***83680***


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Item ID: D4016-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hinge Half, Lid
Start Date: 4/23/2012 Start Qty: 18.00 ***18*** Cust Item ID:
Required Date: 4/30/2012 Req'd Qty: 18.00 ***18*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/5/22 
mf
12-05-22



Picklist Print

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Page 1

Work Order ID: 83680

Parent Item: D4016-3

Parent Item Name: Hinge Half, Lid

Start Date: 4/23/2012

Required Date: 4/30/2012

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as per dwg REV.A DD
10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000 304 bar 1.00x1.00		Purchased	No			100	f	1.0470	0.08	1.5157895			

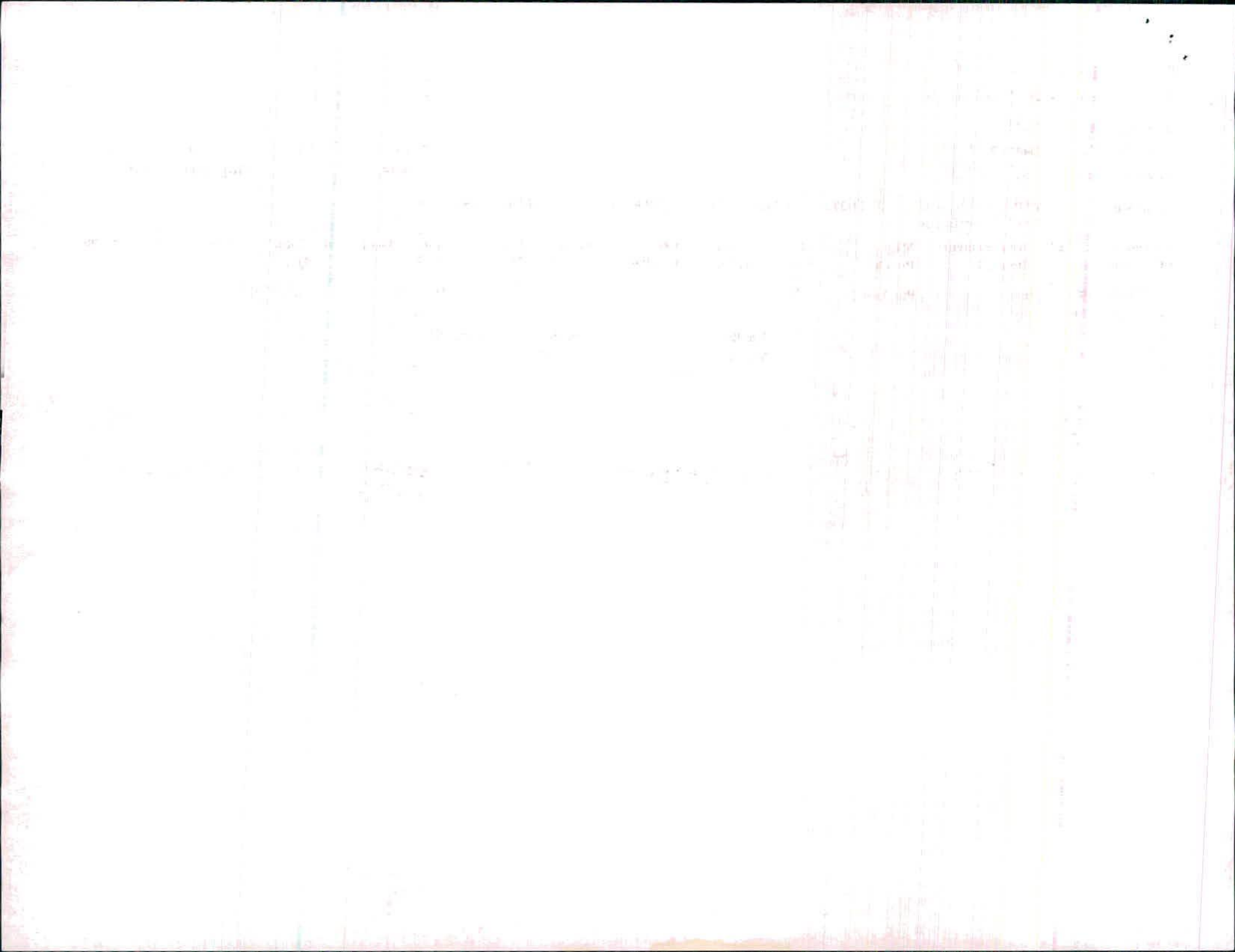
Location	Loc Qty	Loc Code
MAT050	1.047	
113290	1.047	

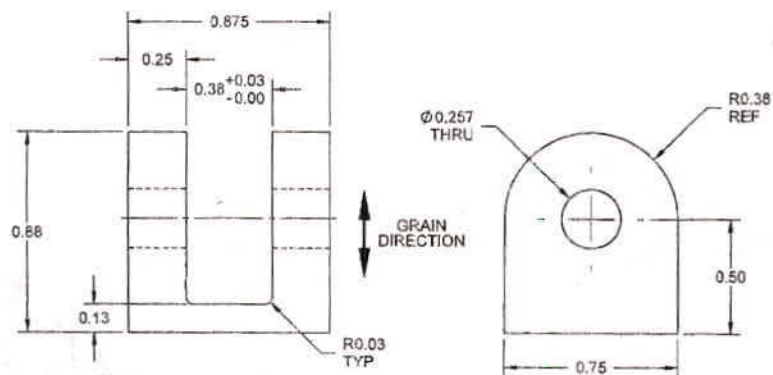
1.5 x 1.5

This Batch only
4/12/05-16

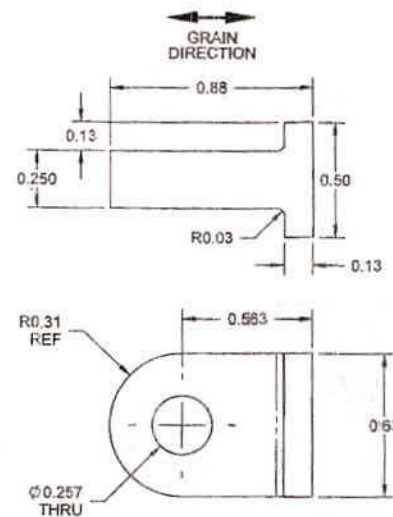
304 BAR 1.5X1.5 = M116719

~~1.515~~
.336 on 12/05/22 ✓





D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL - 1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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